

Date: Thursday, 2/8/2007 12:43:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE WELDMENT
 Job Number : 30719
 Estimate Number : 12064
 P.O. Number : N/A
 This Issue : 2/8/2007 S.O. No. : N/A
 Prsht Rev. : NC Part Number : D3355045
 First Issue : N/A Type : LARGE FAB ASSY Drawing Number : D3355 REV B
 Previous Run : 29522 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 2/23/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By :
 Comment : est rev A 06.01.20 new issue EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 D33551 handle tip



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty part number description batch
 1 D3355-1 handle tip 330703

Ppl 07-02-21

Ppl 07-02-10

B ①

2.0 D33553 LARGE TUBING



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty part number description batch
 1 D3355-3 large tubing 326942

Ppl 07-02-21

Ppl 07-02-10

B ①

3.0 238043 DOWEL PIN 250 X 1.5



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

pin

Batch: 1716684

Ppl 07-02-21

Ppl 07-02-10

B ①

4.0 VA7130 spring plunger



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

pick:

qty part number description batch
 1 VA-7130 spring plunger 17103546

Ppl 07-02-21

Ppl 07-02-10

B ①

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE WELDMENT

Job Number: 30719

Part Number: D3355045

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Cpl 07.02.10

①



Cpl 07.02.21

Comment: Weld assembly as per dwg

6.0

QC5/9

WELD INSPECTION

~~07/02/12~~ 07/02/12 (3)

7.0

POWDER COATING

POWDER COATING



m18052



Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3

E-2/YK

07/02/12 (3)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

07/02/12 (3)

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Cpl 07.02.21 ①



PTO

Comment: LARGE FABRICATION RESOURCE 1

Install spring plunger per dwg D3355

Cpl 07.02.12

③

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/02/21 07/02/13 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W521

Cpl 07.02.21

①

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/02/22 ①

Job Completion



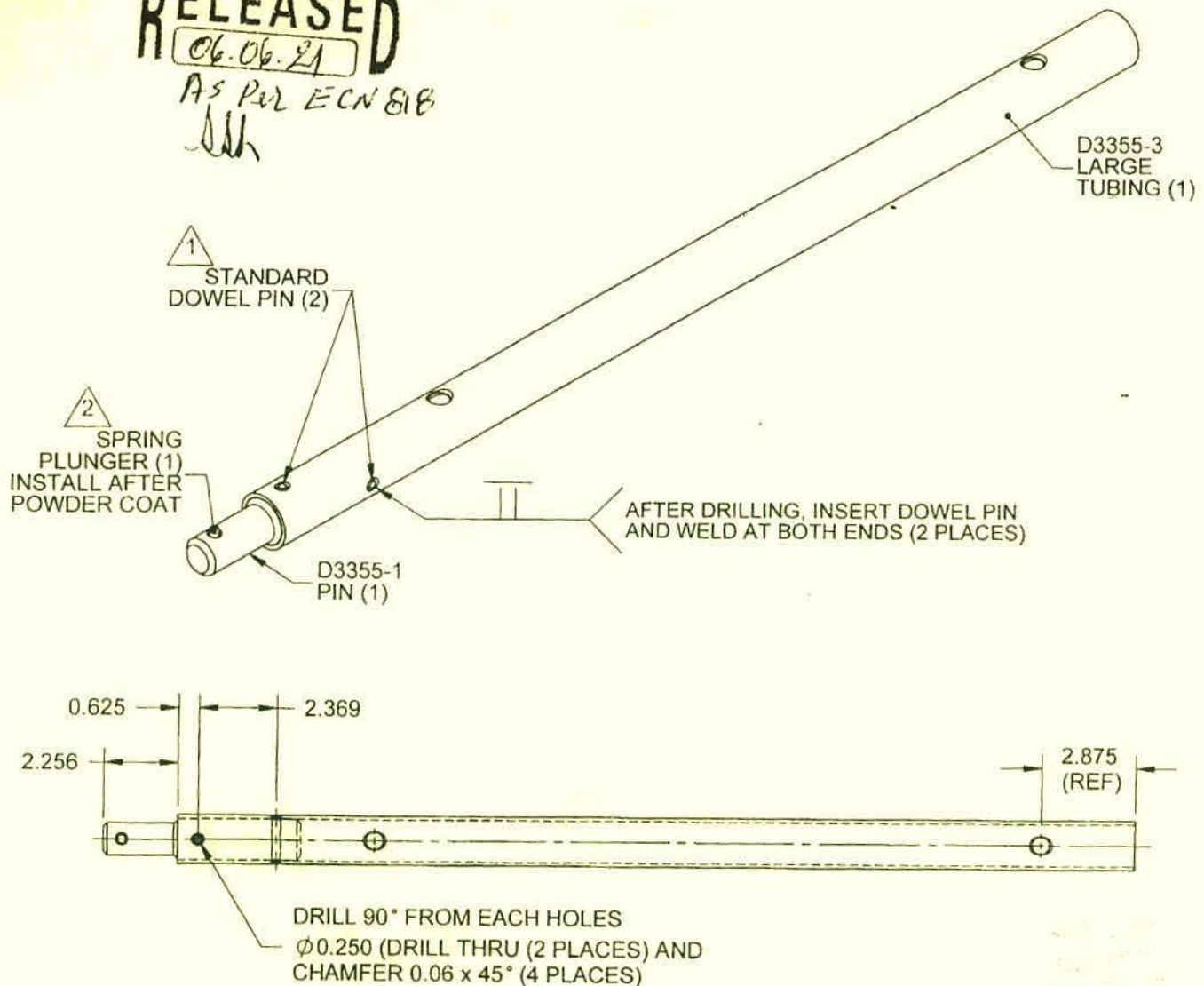
U 07.02.22

DART

DESIGN RF	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3355	REV. B SHEET 2 OF 6
DATE 06.05.31	TITLE HANDLE WELDMENT		SCALE 1:5

RELEASED
06.06.21

AS PER ECN 818

[Signature]**D3355-045 BOTTOM PART****NOTES:**

- 1) STEEL STANDARD GROUND DOWEL PIN, $\varnothing 0.250 \times 1.50$ LONG
POSSIBLE SUPPLIER: SPAENAU, P/N 238-043
- 2) SPRING PLUNGER, POSSIBLE SUPPLIER: REID TOOLS SUPPLY CO. P/N VA-7130
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.5
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.010 TO 0.020

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